



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3078-042
Job Sheet 211234



Part No: D3078-042

Job Qty: 3 pcs

Part Name: Step Assembly, Hi Short RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/9/20

Job Tracking No:

Due Date: 8/3/20

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV B IPP REV:A 15.10.21 NEW ISSUE DD VERF:JLM IPP REV:B 15.11.12 REV.C3 DD VERF:JLM
IPP REV:C 16.03.15 DWG REV:B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
110	Large Fab - Steps - 1	3 pcs			0.00	3.00	Large Fab - 1			
							Large Fab - 10			
							Large Fab - 2			
							Large Fab - 3			
							Large Fab - 4			
							Large Fab - 5			
							Large Fab - 6			
							Large Fab - 7			
							Large Fab - 8			
							Large Fab - 9			
							Large Fab - 11 (Various)			
							Large Fab - 12			
120	QC 5	3 pcs			0.00	0.00	QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
							QC 5 - 40			
							QC 5 - 61			

MAL

OCT 09 2020

98-6
24
DAS

OCT 13 2020

DAS
24
9-89

DART

AEROSPACE

Container No: S305862

: D3078-042

No: 211234

al No/Batch: S305862

ion:

ctor:

Date:

uctions: Various STC's

Date: 10/09/20

Dart Aerospace Ltd.

1270 Aberdeen Street

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CANADA

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7900 94

MAL OCT 09 2020

OCT 13 2020 DAS 24 9-89



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Container No: S305862



Part: D3078-042

Job No: 211234

Serial No/Batch: S305862

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/09/20

Plex 7/9/20 10:33 AM Dart.lajeunesse.marie

130 Large Fab - Welded Assy-2-B4B	3 pcs	0.00 3.60	QC 5 - 81	
			QC 5 - 82	
			Large Fab - 1 - B4B	
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	
			Large Fab - 5 - B4B	
			Large Fab - 6 - B4B	
			Large Fab - 7 - B4B	CC 10-14-20
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
140 QC 9	3 pcs	0.00 0.00	QC 9 - 10	
			QC 9 - 18	
			QC 9 - 24	DAS 24
			QC 9 - 43	9-89
			QC 9 - 50	
			QC 9 - 9	
150 QC 5	3 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	DAS 24
			QC 5 - 3	9-89
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			QC 5 - 82	
160 Handfinish - 1-1 Chemical-B4B	3 pcs	0.00 0.62	Handfinish - 1 - 1 - B4B	
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	

			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	DAS
			Handfinish - 1 - 22 - B4B	47 OCT 19 2020
170 QC 7	3 pcs	0.00 0.00	QC 7 - 10	9-89
			QC 7 - 13	
			QC 7 - 14	
			QC 7 - 15	
			QC 7 - 17	
			QC 7 - 18	DAS
			QC 7 - 19	19
			QC 7 - 2	9-89
			QC 7 - 28	20-10-20
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	
			QC 7 - 36	
			QC 7 - 37	
			QC 7 - 41	
			QC 7 - 47	
			QC 7 - 48	
			QC 7 - 51	
			QC 7 - 58	
			QC 7 - 59	
			QC 7 - 60	
			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	
			QC 7 - 43	
			QC 7 - 61	
			QC 7 - 81	
			QC 7 - 76	
			QC 7 - 79	
			QC 7 - 83	
			QC 7 - 82	
			QC 7 - 87	
200 Large Fab - Welded Assy-3-B4B	3 pcs	0.00 3.60	Large Fab - 1 - B4B	
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	
			Large Fab - 5 - B4B	
			Large Fab - 6 - B4B	
			Large Fab - 7 - B4B	CC 10-20-2020
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
210 QC 10	3 pcs	0.00 0.00	QC 10 - 10	
			QC 10 - 18	
			QC 10 - 24	68-6 DAS
			QC 10 - 43	47 24 OCT 20 2020
			QC 10 - 50	DAS 9-89
			QC 10 - 58	
			QC 10 - 9	

220 QC 5	3 pcs	0.00 0.00	QC 10 - 68	
			QC 10 - 81	
			QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			QC 5 - 82	
230 Handfinish - 6-1- Touch Up- B4B	3 pcs	0.00 0.62	Handfinish - 6 - 1 - B4B	
			Handfinish - 6 - 2 - B4B	
			Handfinish - 6 - 3 - B4B	
			Handfinish - 6 - 4 - B4B	
			Handfinish - 6 - 5 - B4B	
			Handfinish - 6 - 6 - B4B	
			Handfinish - 6 - 7 - B4B	
			Handfinish - 6 - 8 - B4B	
			Handfinish - 6 - 9 - B4B	
			Handfinish - 6 - 10 - B4B	
			Handfinish - 6 - 11 - B4B	
			Handfinish - 6 - 12 - B4B	
			Handfinish - 6 - 13 - B4B	
			Handfinish - 6 - 14 - B4B	
			Handfinish - 6 - 15 - B4B	
			Handfinish - 6 - 16 - B4B	
			Handfinish - 6 - 17 - B4B	
			Handfinish - 6 - 18 - B4B	
			Handfinish - 6 - 19 - B4B	
			Handfinish - 6 - 20 - B4B	
			Handfinish - 6 - 21 - B4B	
			Handfinish - 6 - 22 - B4B	
240 Powdercoat - 1 White Gl(A)- B4B	3 pcs	0.00 0.57	Powdercoat - 1 - B4B	
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	
			Powdercoat - 4 - B4B	
			Powdercoat - 5 - B4B	
			Powdercoat - 6 - B4B	
			Powdercoat - 7 - B4B	
			Powdercoat - 8 - B4B	
			Powdercoat - 9 - B4B	
			Powdercoat - 10 - B4B	
250 Handfinish - 3-1- WingWalk- B4B	3 pcs	0.00 0.38	Handfinish - 3 - 1 - B4B	
			Handfinish - 3 - 2 - B4B	
			Handfinish - 3 - 3 - B4B	
			Handfinish - 3 - 4 - B4B	
			Handfinish - 3 - 5 - B4B	

https://www.plexonline.com/c9de6d89-d0a3-4d3a-ae31-603caf10712f/Plexus_Control/Report_View_2.asp?URL=../Part/Job_Sheet.asp&Report=Tru... 5/6

300 QC 21 - SA	3 pcs	0.00 0.00	Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
			QC 21 - SA - 21	DAS 21 OCT 22 2020
			QC 21 - SA - 70	9-88
			QC 21 - SA - 9	
			QC 21 - SA - 77	

Part Op 110 - (Fabricate per Drwg) 1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078 2-Drill extrusion as per Dwg Descriptions: D3078 using Jig DT8680 for rivets. 3-Debur & buff scratches
 120 - QC5- Inspect part completeness to step on W/O
 130 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Bevel end for welding FWD ONLY 2-Weld Support, weld Fwd End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod _____ 3-Grind End Plate flush
 140 - (QC9- Inspect visual per QSI004- Fusion Welds)
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Chemical Conversion Coat per QSI005 4.1)
 170 - (QC7-Inspect Chemical Conversion Coat)
 200 - (Weld per dwg A/R Aluminum rod Batch: _____) 1- Rivet Leg Assembly as per Dwg D3078. 2-Bevel Aft end for welding 3-Inspect for foreign object as per QSI 024 4-Weld Aft End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod _____ 5-Grind End Plate flush
 210 - (QC10- Inspect visual per QSI004- ground welds)
 220 - (QC5- Inspect part completeness to step on W/O)
 230 - (Touch up alodine)
 240 - (White Gloss (Ref: 4.3-5.1) per QSI005 4.3-Alum) START TIME: 8:55 AM 11/25/14/69. 320°
 FINISH TIME: 9:25
 250 - (Wing Walk as per dwg QSI005 4.4 Batch _____)
 260 - (QC3- Inspect Part Finish)
 290 - Identify as per dwg & Stock Location: _____
 300 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	1.5000 pcs (.5 ea)	110-Large Fab - Steps - 1	5269726
D3067-1	End Plate	6 pcs (2 ea)	130-Large Fab - Welded Assy-2- B4B	5283522
D3219-3	Plate	6 pcs (2 ea)	130-Large Fab - Welded Assy-2- B4B	5229367
D3065-041	Step Leg Assembly	3 pcs (1 ea)	200-Large Fab - Welded Assy-3- B4B	5294708
D3066-1	Spacer	6 pcs (2 ea)	200-Large Fab - Welded Assy-3- B4B	5268849
MS20600-AD4W4	Rivet	48 Ea (16 ea)	200-Large Fab - Welded Assy-3- B4B	5251801

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2622-120C	2	259	0
130-Large Fab - Welded Assy-2- B4B	D3067-1	6	146	0
	D3219-3	6	66	0
200-Large Fab - Welded Assy-3- B4B	D3065-041	3	13	0
	D3066-1	6	183	0
	MS20600-AD4W4	48	1,598	0

Part Specifications

Specifications could not be found.

Plex 7/9/20 10:33 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					